

PCT

WORLD INTELLECTUAL PROPERTY ORGANIZATION
International Bureau



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ : B22F 1/00, C10M 107/44	A1	(11) International Publication Number: WO 95/33589 (43) International Publication Date: 14 December 1995 (14.12.95)
(21) International Application Number: PCT/SE95/00636 (22) International Filing Date: 1 June 1995 (01.06.95) (30) Priority Data: 9401922-1 2 June 1994 (02.06.94) SE (71) Applicant (for all designated States except US): HÖGANÄS AB [SE/SE]; S-263 83 Höganäs (SE). (72) Inventors; and (75) Inventors/Applicants (for US only): STORSTRÖM, Helge [SE/SE]; Lerbergets byaväg 23 B, S-263 52 Höganäs (SE). JOHANSSON, Björn [SE/SE]; Långgatan 19, S-263 32 Höganäs (SE). (74) Agent: AWAPATENT AB; P.O. Box 5117, S-200 71 Malmö (SE).		(81) Designated States: AU, BR, CA, CN, JP, KR, MX, PL, RU, SG, US, European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE). Published <i>With international search report.</i>
(54) Title: LUBRICANT FOR METAL-POWDER COMPOSITIONS, METAL-POWDER COMPOSITION CONTAINING THE LUBRICANT, METHOD FOR MAKING SINTERED PRODUCTS BY USING THE LUBRICANT, AND THE USE OF SAME (57) Abstract A lubricant for metallurgical powder compositions contains an oligomer of amide type, which has a weight-average molecular weight M_w of 30,000 at the most. A metal-powder composition containing the lubricant, as well as a method for making sintered products by using the lubricant, are also disclosed. Further, the use of the lubricant in warm compaction is described.		

BEST AVAILABLE COPY

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AT	Austria	GB	United Kingdom	MR	Mauritania
AU	Australia	GE	Georgia	MW	Malawi
BB	Barbados	GN	Guinea	NE	Niger
BE	Belgium	GR	Greece	NL	Netherlands
BF	Burkina Faso	HU	Hungary	NO	Norway
BG	Bulgaria	IE	Ireland	NZ	New Zealand
BJ	Benin	IT	Italy	PL	Poland
BR	Brazil	JP	Japan	PT	Portugal
BY	Belarus	KE	Kenya	RO	Romania
CA	Canada	KG	Kyrgyzstan	RU	Russian Federation
CF	Central African Republic	KP	Democratic People's Republic of Korea	SD	Sudan
CG	Congo	KR	Republic of Korea	SE	Sweden
CH	Switzerland	KZ	Kazakhstan	SI	Slovenia
CI	Côte d'Ivoire	LI	Liechtenstein	SK	Slovakia
CM	Cameroon	LK	Sri Lanka	SN	Senegal
CN	China	LU	Luxembourg	TD	Chad
CS	Czechoslovakia	LV	Latvia	TG	Togo
CZ	Czech Republic	MC	Monaco	TJ	Tajikistan
DE	Germany	MD	Republic of Moldova	TT	Trinidad and Tobago
DK	Denmark	MG	Madagascar	UA	Ukraine
ES	Spain	ML	Mali	US	United States of America
FI	Finland	MN	Mongolia	UZ	Uzbekistan
FR	France			VN	Viet Nam
GA	Gabon				

BEST AVAILABLE COPY

LUBRICANT FOR METAL-POWDER COMPOSITIONS, METAL-POWDER
COMPOSITION CONTAINING THE LUBRICANT, METHOD FOR MAKING
SINTERED PRODUCTS BY USING THE LUBRICANT, AND THE USE
OF SAME

Field of the Invention

This invention relates to a lubricant for metallurgical powder compositions, as well as a metal-powder composition containing the lubricant. The invention further concerns a method for making sintered products by using the lubricant, as well as the use of the lubricant in a metal-powder composition in warm compaction. Particularly, the invention concerns lubricants which, when warm-pressed, result in products having high unsintered strength (green strength).

Background of the Invention

In industry, the use of metal products manufactured by compacting and sintering metal-powder compositions is becoming increasingly widespread. A number of different products of varying shapes and thicknesses are being produced, and the quality requirements placed on these products are continuously raised. Thus, it is of paramount importance that the manufactured metal products have high density as well as high strength.

In metal compaction, different standard temperature ranges are used. Thus, cold pressing is predominantly used for compacting metal powder (the powder has room temperature). Use is also made of hot isostatic pressing (HIP) and warm pressing (compaction at temperatures between those used in cold pressing and HIP). Both cold pressing and warm pressing require the use of a lubricant.

Compaction at temperatures above room temperature has evident advantages, yielding a product of higher density.

**CONFIRMATION
COPY**

sity and higher strength than compaction performed at lower pressures.

Most of the lubricants used in cold compaction cannot be used in high-temperature compaction, since they
5 seem to be effective within a limited temperature range only. An ineffective lubricant considerably increases the wear of the compacting tool.

How much the tool is worn is influenced by various factors, such as the hardness of the material of the
10 tool, the pressure applied, and the friction between the compact and the wall of the tool when the compact is ejected. This last factor is strongly linked to the lubricant used.

The ejection force is the force required for eject-
15 ing the compact from the tool. Since a high ejection force not only increases the wear of the compacting tool but also may damage the compact, this force should preferably be reduced.

However, the use of a lubricant may create problems
20 in compaction, and it is therefore important that the lubricant is well suited to the type of compaction carried out.

In order to perform satisfactorily, the lubricant should, in the compacting operation, be forced out of the
25 pore structure of the powder composition, and into the gap between the compact and the tool, thereby lubricating the walls of the compacting tool. By such lubrication of the walls of the compacting tool, the ejection force is reduced.

30 Another reason why the lubricant has to emerge from the compact is that it would otherwise create pores in the compact after sintering. It is well-known that large pores have an adverse effect on the dynamic strength properties of the product.

Background Art

US-P-5,154,881 (Rutz) discloses a method for making sintered products on the basis of a metal-powder composition containing an amide lubricant. Apart from the lubricant, which consists of the reaction product of a monocarboxylic acid, a dicarboxylic acid and a diamine, the composition contains iron-based powder. The amide lubricant thus consists of an amide product mixture chiefly made up of diamides, monoamides, bisamides and polyamides (cf column 4, lines 55-56). Especially preferred as a lubricant is ADVAWAX® 450 or PROMOLD® 450, which is an ethylenebisstearamide product.

Furthermore, US-P-4 955 789 (Musella) describes warm compaction more in general. According to this patent, lubricants generally used for cold compaction, e.g. zinc stearate, can be used for warm compaction as well. In practice, however, it has proved impossible to use zinc stearate or ethylenebisstearamide (commercially available as ACRAWAX®), which at present are the lubricants most frequently used for cold compaction, for warm compaction. The problems which arise are due to difficulties in filling the die in a satisfactory manner.

Accordingly, an object of the the invention is to provide a lubricant enabling the manufacture of compacted products having high green strength and high green density, as well as sintered products having high sintered density and low ejecting force from the lubricant in combination with iron-based powders having high compressibility. The improvements in green strength are especially important. High green strength can make the compact machinable and facilitates the handling of the compact between compaction and sintering, and it further results in a sintered product of high density and strength. This is especially important in the case of thin parts. Thus, the product must keep together during the handling between compaction and sintering without cracking or be-

ing otherwise damaged, the compact being subjected to considerable stresses when ejected from the compacting tool.

5 Summary of the Invention

The lubricant according to the invention essentially consists of an oligomer of amide type, which has a weight-average molecular weight M_w of 30,000 at the most and, preferably, at least 1,000. Most preferably M_w varies between 2,000 and 20,000. In this context the expression "oligomer" is intended to include also lower polyamides i.e. polyamides having a molecular weight, M_w of 30 000 at the most. It is important that the oligomer does not have too high a molecular weight, since the density of the product will then be too low to be of interest in industrial applications. In this context, the phrase "essentially consists of" means that at least 80% of the lubricant, preferably at least 85% and most preferably 90% by weight, is made up of the oligomer according to the invention.

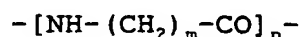
The invention further concerns a metal-powder composition containing iron-based powder and the above-mentioned lubricant, as well as a method for making sintered products. The method according to the invention comprises the steps of

- a) mixing an iron-based powder and a lubricant to a metal-powder composition,
- b) preheating the metal-powder composition to a predetermined temperature,
- 30 c) compacting the metal-powder composition in a tool, and
- d) sintering the compacted metal-powder composition at a temperature above 1050°C, use being made of a lubricant according to the invention.

35 The present invention further relates to the use of the lubricant according to the invention in a metallurgical powder composition in warm pressing.

Detailed description of the Invention

The lubricant according to the invention contains oligomers which include lactams containing the repeating unit



wherein m is in the range of 5-11, and n is in the range of 5-50.

Moreover, the oligomer may derive from diamines and dicarboxylic acids and contain the repeating unit



wherein m and n are in the range of 4-12, m+n being greater than 12, and x is in the range of 2-25.

The oligomers containing the above-mentioned repeating units may have different terminal groups. Suitable terminal groups for the position of $-\text{NH} \dots$ are, for instance, $-\text{H}$; $-\text{CO}-\text{R}$, wherein R is a straight or branched C_2-C_{20} aliphatic or aromatic group, preferably lauric acid, 2-ethylhexanoic acid or benzoic acid; and $-\text{CO}-(\text{CH}_2)_n-\text{COOH}$, wherein n is 6-12. Suitable terminal groups for the position of $\dots-\text{CO}]$, are for instance, $-\text{OH}$; $-\text{NH}-\text{R}$, wherein R is a straight or branched C_2-C_{22} aliphatic group or aromatic group, preferably C_6-C_{12} aliphatic group; and $-\text{NH}-(\text{CH}_2)_n-\text{NH}_2$, wherein n is 6-12.

Further, the oligomers in the lubricant according to the invention may have a melting point peak in the range of $120-200^\circ\text{C}$ and have a porous or nonporous structure.

The lubricant can make up 0.1-1% by weight of the metal-powder composition according to the invention, preferably 0.2-0.8% by weight, based on the total amount of the metal-powder composition. The possibility of using the lubricant according to the present invention in low

amounts is an especially advantageous feature of the invention, since it enables high densities to be achieved.

As used in the description and the appended claims, the expression "iron-based powder" encompasses powder essentially made up of pure iron; iron powder that has been
5 prealloyed with other substances improving the strength, the hardening properties, the electromagnetic properties or other desirable properties of the end products; and particles of iron mixed with particles of such alloying
10 elements (diffusion annealed mixture or purely mechanical mixture). Examples of alloying elements are copper, molybdenum, chromium, manganese, phosphorus, carbon in the form of graphite, and tungsten, which are used either separately or in combination, e.g. in the form of com-
15 pounds (Fe_3P and FeMo). Unexpectedly good results are obtained when the lubricants according to the invention are used in combination with iron-based powders having high compressability. Generally, such powders have a low carbon content, preferably below 0.04% by weight.
20 Such powders include e.g. Distaloy AE, Astaloy Mo and ASC 100.29, all of which are commercially available from Höganäs AB, Sweden.

Apart from the iron-based powder and the lubricant according to the invention, the powder composition may
25 contain one or more additives selected from the group consisting of binders, processing aids and hard phases. The binder may be added to the powder composition in accordance with the method described in US-P-4,834,800 (which is hereby incorporated by reference).

30 The binder used in the metal-powder composition may consist of e.g. cellulose ester resins, hydroxyalkyl cellulose resins having 1-4 carbon atoms in the alkyl group, or thermoplastic phenolic resins.

35 The processing aids used in the metal-powder composition may consist of talc, forsterite, manganese sulphide, sulphur, molybdenum disulphide, boron nitride, tellurium, selenium, barium difluoride and calcium di-

fluoride, which are used either separately or in combination.

The hard phases used in the metal-powder composition may consist of carbides of tungsten, vanadium, titanium, niobium, chromium, molybdenum, tantalum and zirconium, nitrides of aluminium, titanium, vanadium, molybdenum and chromium, Al_2O_3 , B_4C , and various ceramic materials.

Apart from the lubricant according to the invention, the metal-powder composition may, if so desired, contain other lubricants, such as zinc stearate, lithium stearate and lubricants of amide wax type.

With the aid of conventional techniques, the iron-based powder and the lubricant particles are mixed to a substantially homogeneous powder composition.

Preferably, the lubricant according to the invention is added to the metal-powder composition in the form of solid particles. The average particle size of the lubricant may vary, but preferably is in the range of 3-100 μm .

If the particle size is too large, it becomes difficult for the lubricant to leave the pore structure of the metal-powder composition during compaction and the lubricant may then give rise to large pores after sintering, resulting in a compact showing impaired strength properties.

In warm pressing according to the invention, the metal-powder composition is advantageously preheated before being supplied to the heated compacting tool. In such preheating, it is of importance that the lubricant does not begin to soften or melt, which would make the powder composition difficult to handle when filling the compacting tool, resulting in a compact having a nonuniform density and poor reproducibility of part weights. Moreover, it is important that no partial premelting of the lubricant occurs, i.e. the lubricant is a uniform product.

The steps of the warm compaction process are the following:

- a) mixing an iron powder, a high-temperature lubricant and optionally an organic binder;
- 5 b) heating the mixture, preferably to a temperature of at least 120°C;
- c) transferring the heat-powder composition to a die, which is preheated to a temperature of preferably at least 120°C; and compacting the composition at an elevated
- 10 temperature of preferably at least 120°C; and
- d) sintering the compact at a temperature of at least 1050°C.

In step b) of the method, the powder composition is preferably preheated to a temperature of 5-50°C below the

15 melting point of the oligomer. Also, the tool is conveniently preheated to a temperature of 0-30°C above the temperature of the preheated metal-powder composition.

A few tests will now be accounted for in order to illustrate that the invention is effective and yields

20 products of high green density as well as high green strength.

TEST 1

Table 1 below states a number of lubricants by indicating melting point peak, weight-average molecular

25 weight M_w , measured green density (GD) and ejection force (Ej.F) in warm compaction of Distaloy AE (marketed by Höganäs AB), 0.6% by weight of lubricant and 0.3% by weight of graphite. The compaction pressure was 600 MPa,

30 and the tool had a temperature of 150°C. The temperature of the incoming powders was 130°C.

Table 1
Lubricants according to the invention

Lubricant	Mw g/mol	GD g/cm ³	Ej F kP/cm ²	Particle- size µm	Melting point peak
Orgasol 3501	6500	7,34	170	10	140
Orgasol 2001	18000	7,22	150	5	176
Orgasol 2002 ¹⁾	40000	7,07	-	30	?
Fe 4908	4000	7,29	140		167
Promold® ²⁾	?	7,30			142
EBS ³⁾	590	-	-	-	140
Grilamid L16 ⁴⁾	35000	6,99	306		
H 2913-L ⁴⁾	2000	7,32	139*		144

- 5 1) outside the scope of the invention
 2) lubricant according to US Patent 5,154,891 (substantially
 ethylene bisstearamide = EBS)
 3) ethylene bisstearamide - impossible to get acceptable
 reproduction in filling operations at elevated temperature
 10 4) oligomer of the type polyamide 12
 * uneven ejection curve

Lubricant FE 4908 consists of oligomers of the type
 polyamid 12 having a nonporous structure, m being 12.

- 15 Orgasol®2001 UD NAT 1, Orgasol®3501 EXD NAT 1 as
 well as Orgasol®2002 are commercial products from Elf
 Atochem, France.

- The green density was measured according to ISO 3927
 1985, and the ejection force was measured according to
 20 Höganäs Method 404.

- The melting point peaks for the lubricants are indi-
 cated as the peak values of the melting curve, which was
 measured with the aid of Differential Scanning Calori-
 metry (DSC) technique on a Model 912S DSC instrument from
 25 TA Instruments, New Castle, DE 197201 USA.

As appears from Table 1, high green densities can be
 attained, while the ejection forces remain low, when us-
 ing oligomers according to the invention as lubricants.
 Oligomers of high molecular weight, on the other hand,

10

result in too low a green density. However, too low a molecular weight results in an uneven ejection force.

TEST 2

5 The following test was performed in order to establish whether the temperature of the powders had any effect on GD and Ej.F.

10 As composition including FE 4908 from Test 1 above was compacted in a tool that had been preheated to a temperature of 150°C. The temperature of the incoming powders varied. The results are indicated in Table 2 below.

Table 2

Powder temperature °C	Green density g/cm ³	Ejection force kP/cm ²
20	7.09	151.8
100	7.12	137.0
130	7.14	131.1
150	7.16	133.8
170	7.20	130.1
185	7.35	164.3

15 As appears from Table 2, the green density (GD) increases when the powder temperature approaches the melting point peak of the lubricant. The ejection force seemed to have a minimum value in the range of 5-50°C below the melting point peak of the lubricants. If a certain oligomer is to be used as lubricant with maximum effect,
20 the compaction temperature has to be adapted to suit the melting characteristics of the oligomer.

TEST 3

25 This test was performed in order to compare green density and green strength of compacts resulting from the compaction of powder compositions containing, respectively, a lubricant according to the invention and a lu-

11

bricant according to US-P-5,154,881. Compaction was carried out at different temperatures.

The metal-powder compositions contained the following ingredients.

5

Composition 1 (invention)

Distaloy[®]AE, marketed by Höganäs AB

0.3% by weight of graphite

0.6% by weight of Orgasol[®]2001 UD NAT 1

10

Composition 2 (US-P-5,154,881)

Distaloy[®]AE

0.3% by weight of graphite

0.6% by weight of Promold[®]450, marketed by Morton International, Cincinnati, Ohio.

15

Compaction was carried out in a Dorst press, which had a die temperature of 150°C. The results are indicated in Table 3 below.

20

Table 3

Composi- tion	Powder tem- perature °C	Compaction pressure MPa	Green den- sity g/cm ³	Green strength N/mm ²
1	20	600	7.22	27.4
	100	"	7.22	28.5
	130	"	7.22	29.0
	150	"	7.22	29.7
	170	"	7.24	31.4
	180	"	7.34	41.3
	180	800	7.43	58.5
2	20	600	7.15	20.0
	100	"	7.23	27.0
	120	"	7.25	27.2
	160	"	(7.32) *	(29.5) *

* uncertain values, due to problems when filling the tools.

As appears from Table 3, the two lubricants result in products of comparable properties when the powder temperature is in the range of 20-120°C. At higher powder
5 temperatures, the products compacted with the lubricant according to the invention begin to show remarkably high green densities and green strengths.

The products that had been compacted with Orgasol®
2001 were then sintered in order to ensure that acceptable sintered properties would be obtained, which was the
10 case.

TEST 4

Yet another test was performed in order to compare a
15 metal-powder composition according to the invention and a prior-art metal-powder composition containing the lubricant Promold®450.

The metal-powder compositions contained the following ingredients.

20

Composition 1 (invention)

Distaloy®AE

0.3% by weight of graphite

0.6% by weight of Orgasol®3501 EXD NAT 1

25

Composition 2 (prior art)

as above but with Promold 450 replacing Orgasol as lubricant

30 Compaction was performed in a Dorst press, which had a die temperature of 150°C. The powders had a temperature of 115°C. The results are indicated in Table 4 below.

Table 4

Com- posi- tion	Compac- tion pressure	Ej.F	GD	GS	Sinter- ed den- sity	Dimen- sional change	Flexural strength
	MPa	kP/cm ²	g/cm ³	N/mm ²	g/cm ³	$\Delta L\%$	N/mm ²
1	593	230	7.34	77.6	7.29	+0.085	1443
2	600	327	7.30	27.9	7.29	-0.02	1488

- 5 As appears from Table 4, the product resulting from the compaction of the metal-powder composition according to the invention had a remarkably high green strength.

TEST 5

- 10 Yet another test was performed in order to establish whether the lubricant according to the invention had the same effect when using prealloyed iron powder and pure iron powder.

In a Lödige mixer, two different metal-powder compo-
15 sitions containing the following ingredients were mixed.

1. Astaloy®Mo, a prealloyed iron powder from Höganäs AB (containing 1.5% of Mo), 0.2% of graphite and 0.6% of Orgasol®3501 EXD NAT 1.

2. ASC 100.29, an atomised pure iron powder, 0.2% of
20 graphite and 0.65% of Orgasol®3501.

The results are indicated in Table 5 below.

14

Table 5

Test product	Powder temperature °C	Tool temperature °C	Compaction pressure MPa	Green density g/cm ³
1	120	130	730	7.40
2	120	130	730	7.42

As is evident from Table 5, equally high green densities were obtained with prealloyed and pure iron powders.

Thus, the lubricant according to the invention yields fully acceptable products showing high green density and high green strength, as well as satisfactory properties after sintering.

TEST 6

As appears from the following experiments, the oligomers according to the invention can be used also for cold compaction, even if the results obtained are not as advantageous as those which can be obtained with conventional lubricants for cold compaction. Moreover, the use of an orgasol for cold compaction has been suggested by Molera P in the publication Deformation Metallica/14/1989. The technical data indicates that Molera has used Orgasol 2002, which is a compound having a molecular weight of 40.000. The following lubricants were used:

Kenolube P11 (commercially used lubricant)
 Zinc stearate (" " ")
 Orgasol 2001 EXT D NAT 1
 " 2002 D NAT 1
 " 3502 D NAT 1

Green properties

15

Composition: ASC 100.29 + 0.8% Lubricant (mixed for 2 min in a Lödige labor-mixer).

Speciments: Ø 25 mm; Height approx. 20 mm

Material	A.D. g/cm ³	Flow S/50g	Green density g/cm ³		Ejection Force Kp/cm ²	
			600MPa	800 MPa	600MPa	800 MPa
Kenolube	3.23	24.4	7.15	7.28	148	174
Zinc stearate	3.34	25.6	7.18	7.31	199	233
2001	2.89	26.1	7.02	7.19	294	-*
2002	2.79	25.9	6.94	-*	-*	-*
3502	2.88	24.8	6.95	7.12	285	-*

5

-* The test had to be stopped due to the high ejection force.

Comments

10 Compared with the materials containing Kenolube and Zinc-stearate, the materials admixed with different grades of orgasol give a considerably higher ejection force and lower compressibility. The orgasol materials also reduce the apparent density.

r a c t e r i s e d in that the oligomer has a weight-average molecular weight M_w in the range of 2,000-20,000.

15 4. A lubricant as claimed in claim 1, c h a r a c -
t e r i s e d in that the oligomer includes lactams con-
taining the repeating unit



20

wherein m is in the range of 6-12, and n is in the range of 5-50.

5. A lubricant as claimed in claim 1, c h a r a c -
t e r i s e d in that the oligomer derives from diamines
25 and dicarboxylic acids and contains the repeating unit



wherein m and n are in the range of 4-12, m+n being
30 greater than 12, and x is in the range of 2-25.

6. A lubricant as claimed in claim 1, c h a r a c -
t e r i s e d in that the oligomer has in the position of
-[NH-...terminal groups selected from -H ; -CO-R, wherein
R is a straight or branched C_2 - C_{20} aliphatic or aromatic
35 group, preferably lauric acid, 2-ethylhexanoic acid or
benzoic acid; or -CO-(CH_2) $_n$ -COOH, wherein n is 6-12, and,
in the position of ...-CO]-, terminal groups selected

BEST AVAILABLE COPY

from -OH ; -NH-R, wherein R is a straight or branched C₂-C₂₂ aliphatic group or aromatic group, preferably C₆-C₁₂ aliphatic group; or -NH-(CH₂)_n-NH₂, wherein n is 6-12.

7. A lubricant as claimed in any one of the preceding claims, characterised in that the oligomer has a melting point peak in the range of 120-200°C.

8. A metal-powder composition for warm compaction containing iron-based powder and a lubricant, characterised in that the lubricant essentially consists of an oligomer of amide type, which has a weight-average molecular weight M_w of 30,000 at the most.

9. A metal-powder composition as claimed in claim 8, characterised in that the oligomer has a molecular weight of 2,000-20,000 and is present in an amount of less than 1% by weight.

10. A metal-powder composition as claimed in claim 8 or 9, characterised in that the metal powder is an iron-based powder having high compressability, and that at least 80% of the lubricant is made up of the oligomer.

11. A metal-powder composition as claimed in claim 10, characterised in that the iron-based powder has a carbon content of 0.04% by weight at the most.

12. A metal-powder composition as claimed in any one of claims 8-11, characterised in that the oligomer makes up 0.2-0.8% by weight of the total composition.

13. A metal-powder composition as claimed in any one of claims 8-12, characterised in that it further contains one or more additives selected from the group consisting of binders, processing aids and hard phases.

14. A method for making sintered products, comprising the steps of

a) mixing an iron-based powder and a lubricant to a metal-powder composition,

b) preheating the metal-powder composition to a predetermined temperature,

c) compacting the metal-powder composition in a preheated tool, and

5 d) sintering the compacted metal-powder composition at a temperature above 1050°C,

characterised in that the lubricant essentially consists of an oligomer of amide type, which has a weight-average molecular weight M_w of less than

10 30,000.

15 15. A method as claimed in claim 14, characterised in that the powder composition in step b) is preheated to a temperature of 5-50°C below the melting point of the oligomer.

16. A method as claimed in claim 14 or 15, characterised in that the tool before step c) is preheated to a temperature of 0-30°C above the temperature of the preheated metal-powder composition.

20 17. The use of a lubricant, which essentially consists of an oligomer of amide type having a weight-average molecular weight M_w of 30,000 at the most, in warm compaction.

INTERNATIONAL SEARCH REPORT

International application No.

PCT/SE 95/00636

A. CLASSIFICATION OF SUBJECT MATTER		
IPC6: B22F 1/00, C10M 107/44 According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED		
Minimum documentation searched (classification system followed by classification symbols)		
IPC6: B22F, C10M		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched		
SE,DK,FI,NO classes as above		
Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)		
WPIL		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 5154881 A (HOWARD G. RUTZ ET AL), 13 October 1992 (13.10.92), column 1, lines 54-64; column 4, lines 6-13, 23-28, 50-56 -----	1-17
<input type="checkbox"/> Further documents are listed in the continuation of Box C. <input checked="" type="checkbox"/> See patent family annex.		
<p>* Special categories of cited documents:</p> <p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier document but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p> <p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance: the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone</p> <p>"Y" document of particular relevance: the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art</p> <p>"&" document member of the same patent family</p>		
Date of the actual completion of the international search		Date of mailing of the international search report
5 Sept 1995		21 -09- 1995
Name and mailing address of the ISA/ Swedish Patent Office Box 5055, S-102 42 STOCKHOLM Facsimile No. + 46 8 666 02 86		Authorized officer Hans Bäckström Telephone No. + 46 8 782 25 00

Form PCT/ISA/210 (second sheet) (July 1992)

BEST AVAILABLE COPY

International application No.

PCT/SE 95/00636

Form PCT/ISA/210 (patent family annex) (July 1992)

BEST AVAILABLE COPY